

Date: Friday, 06/06/2008 8:20:04 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : HELI-UTILITY BASKET LH
<b>Job Number</b> : 37413	
<b>Estimate Number</b> : 12554	
<b>P.O. Number</b> :	<b>Part Number</b> : D205541043
<b>This Issue</b> : 06/06/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : IIN D205-541 REV G
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : G
<b>Previous Run</b> : 37723	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/06/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev: C Re-Format 02-08-30 KJ Est Rev: D chg to revG Ecn1157 08-03-19 DD verified by:	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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<b>Comment:</b> Photocopy bluefile & type labels per PPPD205-541-043	CHG002	06/06/24	08.6.11
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2.0	37413A	350/212/130 BASKET LID
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<b>Comment:</b> Sub-Component 350/212/130 BASKET LID	
1 x D2512 Batch <u>37413A</u>	

3.0	37413B	212 BASKET BASE ASS'Y LH
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<b>Comment:</b> Sub-Component 212 BASKET BASE ASS'Y LH	
1 x D3053-041 Batch <u>37413B</u>	

4.0	D2022101	Spacer
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<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
Spacer Batch: <u>37521</u>	

5.0	D2258300	Label
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<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)	
Placard Batch: <u>37538</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37413

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2332041

Lid Prop Assembly 6.69" long



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: 38597

*LU*

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Handle Weldment

Batch: 37853

*LU*

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spring

Batch: M106815 37071

*LU*

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bushing

Batch: 37605

*LU*

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bumper

Batch: 28139

*LU*

11.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M106815

*LU*

12.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M107321

*LU 8/6/15 (U)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37413

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104937

*[Signature]*

14.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M104847

*[Signature]*

15.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M106815

*[Signature]*

16.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M107939

*[Signature]*

17.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M108138

*[Signature]*

18.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M107989

*[Signature]*

19.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 107650

*[Signature]* 10/8/19 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37413

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M107715

*LC*

21.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M107685

*LC*

22.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M107478

*LC*

23.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M107939

*LC*

24.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M18071

*LC*

25.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg.

*CP 08/06/23*

*[Signature]*

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*508/06/23*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 37413

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

28.0

D21991

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 38453

*Handwritten signature*

29.0

D219923

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 39849

*Handwritten signature*

30.0

D219925

Strut Details



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Strut

Batch: 38454

*Handwritten signature*

31.0

D2498

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 37542

*Handwritten signature*

32.0

D2499

Mounting Bracket, 205 Basket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mounting Bracket

Batch: 37543

*Handwritten signature*

33.0

D2515

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: B29138

*Handwritten signature*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

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Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37413

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

D30521

Mounting Lug



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Mounting Lug

Batch: 28522

35.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M107321

36.0

AN412A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Bolt

Batch: M105143

37.0

AN413A

Bolt



Comment: Qty.: 9.0000 Each(s)/Unit Total: 9.0000 Each(s)

Bolt

Batch: M107534

38.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch: M107534

39.0

AN57A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M107013

40.0

AN513A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Bolt

Batch: M107321

Handwritten signature and circled '1'

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Drawing Name: HELI-UTILITY BASKET LH

Job Number: 37413

Part Number: D205541043

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

AN960JD416

Washer



Comment: Qty.: 29.0000 Each(s)/Unit Total : 29.0000 Each(s)  
Washer M107939

42.0

AN960JD516

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)  
Washer  
Batch: M107959

43.0

MS21042L4

Nut



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)  
Nut  
Batch: M107478

44.0

MS21042L5

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Nut  
Batch: M107939

45.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and pack for shipping as per PPP D205-541-043  
Location: RB  
PPP Rev: F

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-06-25

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## 5. PARTS LIST

Qty -043	Qty -044	Part Number	Description
X		D205-541-043	HELI-UTILITY-BASKET LH
	X	D205-541-044	HELI-UTILITY-BASKET RH
2	2	D2022-101	SPACER
1	1	D2199-1	STRUT
1	1	D2199-23	STRUT
1	1	D2199-25	STRUT
1	1	D2258-300	LABEL
1	1	D2332-041	PROP ASSEMBLY
1	1	D2498	MOUNTING LUG
1	1	D2499	MOUNTING LUG
1	1	D2512	BASKET LID ASSEMBLY
2	2	D2515	BUSHING
1	1	D2530	HANDLE ASSEMBLY
2	2	D2535	SPRING
2	2	D2537	BUSHING
2	2	D2931	BUMPER
1	1	D3052-1	MOUNTING LUG
1		D3053-041	BASKET BASE ASSEMBLY, LH
	1	D3053-042	BASKET BASE ASSEMBLY, RH
1	1	* D2446	* SIGN PLATE
1	1	* D2509	* LINER (BASE)
1	1	* D2511	* LINER (END)
2	2	AN3-16A	BOLT
4	4	AN4-7A	BOLT
3	3	AN4-12A	BOLT
9	9	AN4-13A	BOLT
2	2	AN4-14A	BOLT
1	1	AN4-22A	BOLT
1	1	AN4-24A	BOLT
1	1	AN5-7A	BOLT
1	1	AN5-13A	BOLT
4	4	AN5-17A	BOLT
30	30	AN960JD416	WASHER
7	7	AN960JD516	WASHER
2	2	AN960JD8	WASHER
4	4	AN970-4	WASHER
2	2	MS20600AD4W3	RIVET
2	2	MS21042L3	NUT (OR MS21042-3)
20	20	MS21042L4	NUT (OR MS21042-4)
6	6	MS21042L5	NUT (OR MS21042-5)
6	6	* MS24693S272	* SCREW
6	6	* A3235-020-935	* WASHER
6	6	* NAS679A3W	* NUT
4	4	* MS20470AD4-8	* RIVET
42	42	* MS20600AD4W4	* RIVET

\* OPTIONAL EQUIPMENT

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37413

Date: Thursday, 2/14/2008 10:54:06 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/212/130 BASKET LID  
 Job Number : 37413A  
 Estimate Number : 10193  
 P.O. Number :  
 This Issue : 2/14/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2512  
 First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D2512 UNDER REVIEW  
 Previous Run : 37144A Drawing Revision : D2  
 Material :  
 Due Date : 3/15/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Rev Est:W 03.01.31 Added D2012-117 for D130-701-041 KJ/RF  
 Est Rev:N 06.04.05 Added level21 EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 45.7594 f(s)/Unit Total : 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .063" wall

Batch: M108065

SAD 08/06/11

①

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D3166-3 Basket Hoop

B33780

SAD 08/06/11

①

3.0 D2506 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

Batch

1 D2506 Label Plate

B37446

FC 08 06 18

4.0 D23271 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2327-1 Bushing

B37541

B36920

SAD 08/06/12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Date: Thursday, 2/14/2008 10:54:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 37413A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D22321

Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2232-1 Hinge plate

Batch

B.39454 ✓

*del 08/06/12*

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

2 D2581 Mounting Bracket

Batch

B.39046 ✓

*del 08/06/12*

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description

18 sf M304EX0.75-16F Expanded Metal

Batch

~~107856~~ 107856 \*

*FC 08 06 18*

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 *SAD*

2-Cut (4) D2236 From D3166-3 *SAD*

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305

*→ SAD 08/06/12*

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required

*FC 08/06/18*

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*del 08/06/19* ①

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*S 08/06/19* ②

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## Process Sheet

20/06/2008

S.026 07.36

#1 400.7

#2 02512

1337413A

30m air

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 37413A

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

POWDER COATING

POWDER COATING



M1107925



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08-06-20

(X)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.3

Spray Paint: ~108128

Batch: ~107892

08/06/20

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/06/23

(Q)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

08/06/23

(Q)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/25

Job Completion



MF 08-06-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

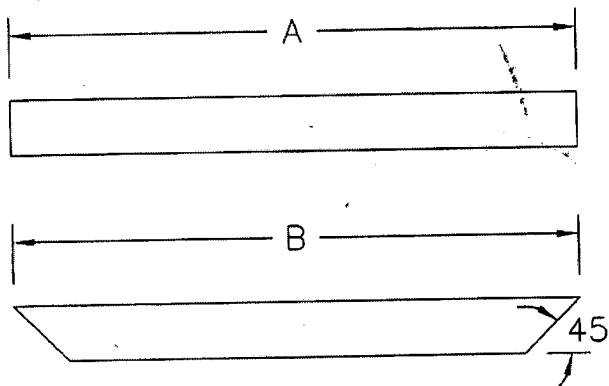


DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 1 OF 4
DATE 01.04.19		TITLE BASKET LID ASSEMBLY (350/212) SCALE NTS	
A	95.11.21	NEW ISSUE	
B	96.05.24	ADDED LATCH CHANNEL & LABEL PLATE	
C	99.07.06	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP. DEO 9074	
D	01.04.19	CHANGE HINGE	
D1	UP 03.01.20	ADD D2012-117 FOR D130-701-041	
D2	UP 04.09.20	TACK WELD ANT-SKID AREA	

RELEASED  
01.04.27 #

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



**UNDER REVIEW**  
08.02.19  
TUBING TO BE  
CHANGED TO 0.065  
WALL SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37413A

D2512-1/-3/-5/-7

CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

ALL DIMENSIONS ARE IN INCHES

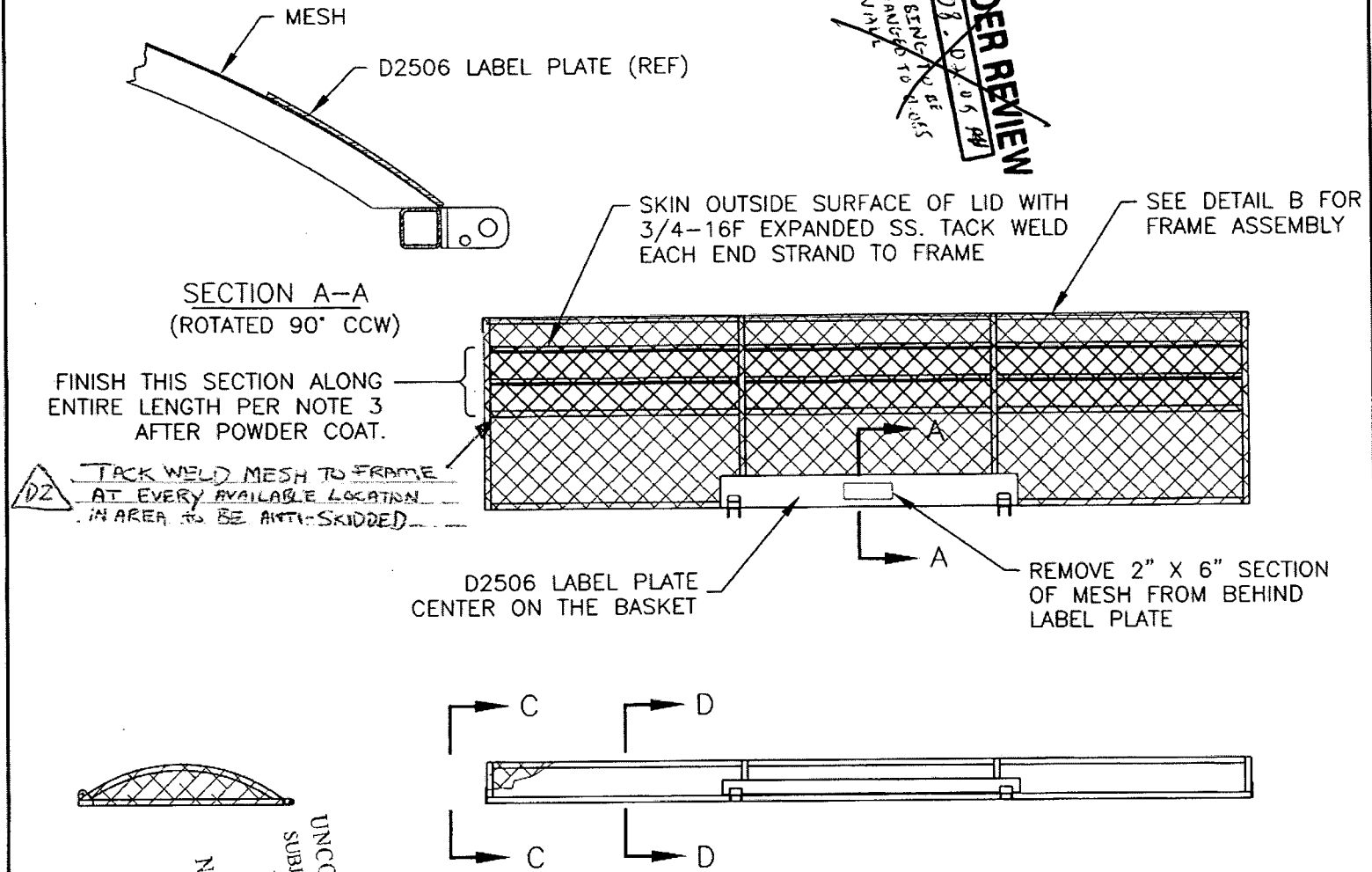
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DESIGN	BW	DRAWN BY	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D2512
DATE	01.04.19	TITLE	BASKET LID ASSEMBLY (350/212)		
				REV. D	SHEET 2 OF 4
				SCALE	1:20

~~UNDER REVIEW~~  
~~08.02.05 PM~~  
~~TUBING 10.05~~  
~~CHANGED TO 4.005~~  
~~WALL~~



*DZ* TACK WELD MESH TO FRAME  
AT EVERY AVAILABLE LOCATION  
IN AREA TO BE ANTI-SKIDDED

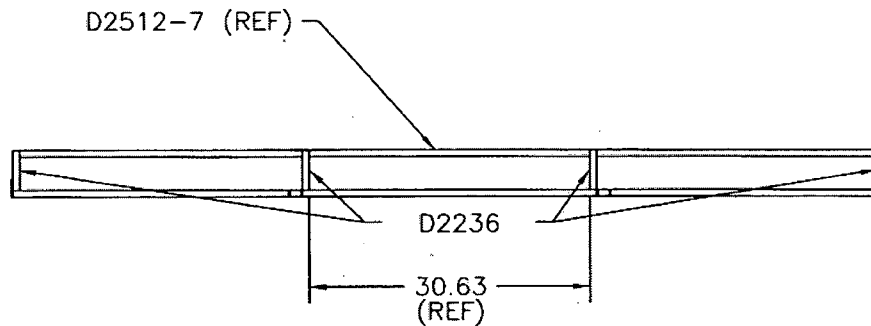
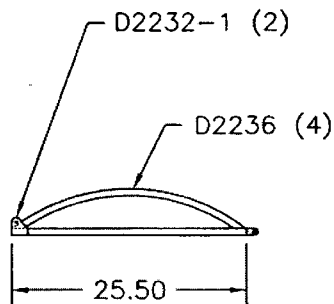


- NO. *39413A*
- WORK ORDER
- RELEASED
- 01.04.21
- SHOP COPY  
RETURN TO  
ENGINEER  
UNCONTROLLED  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE
- BASKET LID ASSEMBLY
- MESH MATERIAL: 3/4-16F EXPANDED SS
- FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- SPRAY PAINT BLACK INSIDE SURFACE
- APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

**DART**



DESIGN	BW	DRAWN BY	SP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	#	APPROVED	#	DRAWING NO.	REV. D
DATE	01.04.19			D2512	SHEET 3 OF 4
				TITLE	SCALE
				BASKET LID ASSEMBLY (350/212)	1:20



**UNDER REVIEW**  
08.04.05  
TUSING TO BE  
CHANGED TO 0.05  
WILE

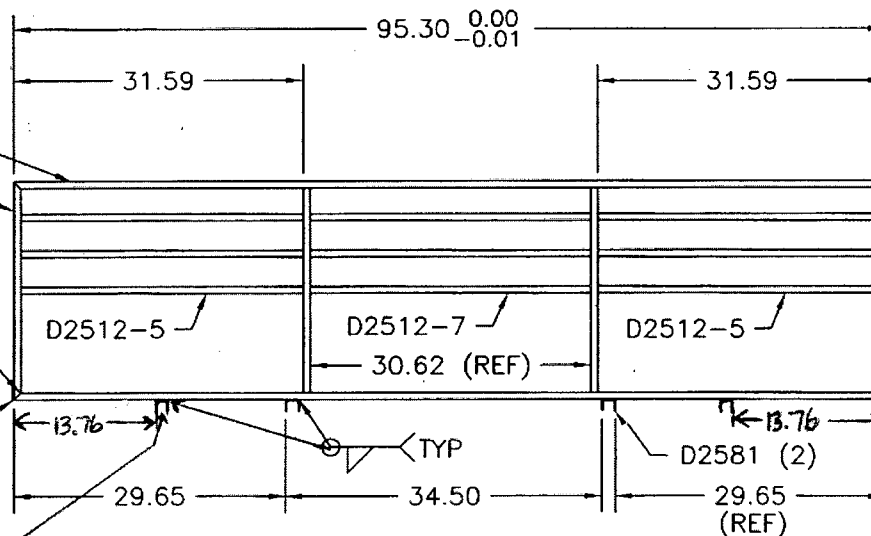
**RELEASED**  
01.04.27

D2512-3 (2)  
D2512-1 (2)

WELD ALL JOINTS  
AS SHOWN

TYP

TYP



D2012-117 CLEVIS  
ADD FOR D130-701-041  
ONLY (2 PLACES)  
SHOP COPY  
RETURN TO  
ENGINEERING  
CONTROLLED COPY  
SPECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37434

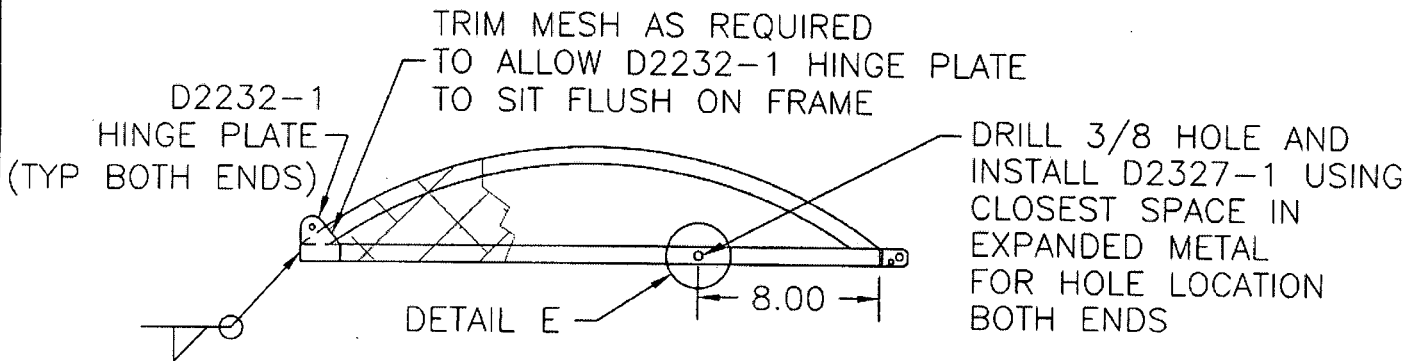
**DETAIL B**

FRAMEWORK SHOWN FOR CLARITY  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

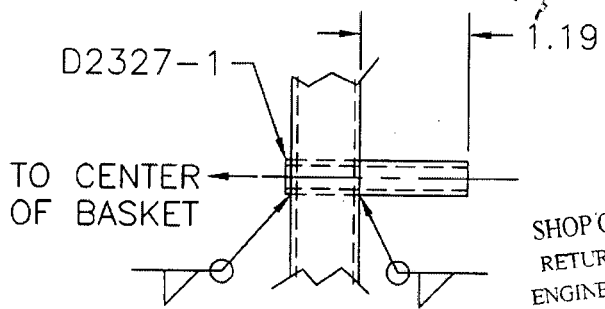




DESIGN BW	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2512	REV. D SHEET 4 OF 4
DATE 01.04.19	TITLE BASKET LID ASSEMBLY (350/212)		SCALE 1:8

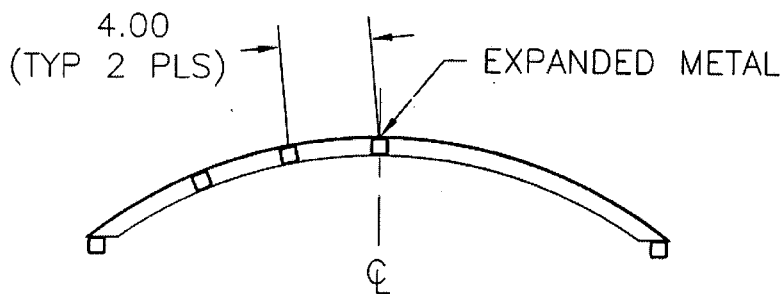


SECTION C-C SIMILIAR BOTH END RIBS



DETAIL E

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37413A



SECTION D-D SAME BOTH CENTER RIBS

**UNDER REVIEW**

08.02.05 PH  
TUBING TO BE  
CHANGED TO 1.065  
WALL

**RELEASED**  
01.04.27

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Date: Friday, 06/06/2008 8:20:19 AM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 212 BASKET BASE ASS'Y LH
<b>Job Number</b> : 37413B	
<b>Estimate Number</b> : 11542	
<b>P.O. Number</b> :	<b>Part Number</b> : D3053041
<b>This Issue</b> : 06/06/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3053 UNDER REVIEW <i>dl</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> :
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 37723B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 13/06/2008 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est. 'C 02.09.04 M304EX0.75-16F was M750-16FXS-S/S K J/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
✓		
<b>Comment:</b> Qty.: 45.5000 f(s)/Unit Total : 45.5000 f(s) 304 SQ Tube.75x.75x.065W  1-Cut Rib from 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: <u>M108065</u>  2-Drill holes in D3053-3 as per dwg D3053 <span style="float: right;">SAO 08/06/11 ①</span>		
2.0	D31661	Basket Hoop
✓		
<b>Comment:</b> Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s) Basket Hoop Cut Qty. 5 D3166-1 Batch: <u>B 39673</u> <span style="float: right;">SAO 08/06/12 ①</span>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
<b>Comment:</b> LARGE FABRICATION RESOURCE 1  1-Cut 5 D2235-3 FROM D3166-1 using DT8365  2-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995 <span style="float: right;">SAO 08/06/12 ①</span>		
4.0	D23273	Spacer Bushing
<b>Comment:</b> Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Spacer Bushing Pick: Qty Part Number Description Batch <u>637544</u> <span style="float: right;">SAO 08/06/12 ①</span>		

Date: Friday, 06/06/2008 8:20:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 37413B

Part Number: D3053041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 D2327-3

Bushing

B37541

PD 08-06-15

5.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Pick:

Qty Part Number Description Batch

2 D2232-3 Hinge plate

B36046

PD 08-06-15

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B39046

PD 08-06-15

7.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 50.4000 sf(s)/Unit Total : 50.4000 sf(s)

Expanded Metal Flat Stai

Pick:

Qty Part Number

Description

Batch

48sq.ft M304EX0.75-16F

Expanded Metal

M107966

540 08/06/17

①

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Remove all markings from material

2-Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

\*\*\*\*Ensure ribs are positionned for LH\*\*\*\*

PD 08-06-18

①

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/06/19 (1)

Date: Friday, 06/06/2008 8:20:19 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212 BASKET BASE ASS'Y LH

Job Number: 37413B

Part Number: D3053041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK ,

Signature: 08/06/19 @

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Take Traveller D205-541-043 to KP

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

OVEN TEMPERATURE: 400°F

FINISH TIME: 9:25am

8:55am

Signature: JS

08-06-20

(X)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Signature: 08/06/23 @

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

Signature: 08/06/23 @

15.0

QC21

FINAL INSPECTION W/O RELEASE



Comment: FINAL INSPECTION W/O RELEASE

08/06/25

Job Completion



mf 08-06-25

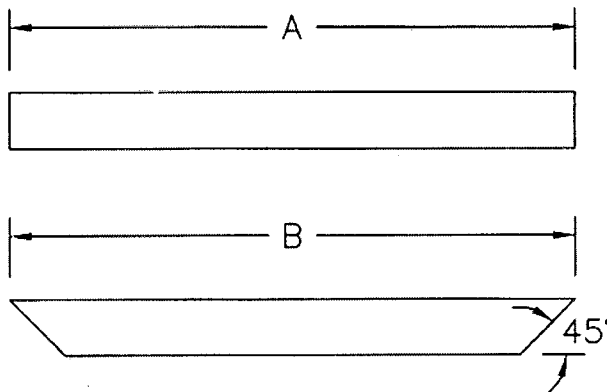


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED A	APPROVED A	DRAWING NO. D3053	REV. A SHEET 1 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE NTS
A	01.11.01	NEW ISSUE	

RELEASED  
01.12.20

PARTS LIST FOR D3053-041/D3053-042 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3053-1	2	—	96.00	RIB
D3053-3	2	—	25.50	RIB
D3053-5	6	23.73	—	RIB
D3053-7	3	25.31	—	RIB
D3053-9	3	19.48	—	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-3	5	N/A	N/A	RIB



**UNDER REVIEW**  
01.02.05 PH  
TUBING TO BE  
CHANGED TO 0.065  
WALL  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37413B

NOTES:

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

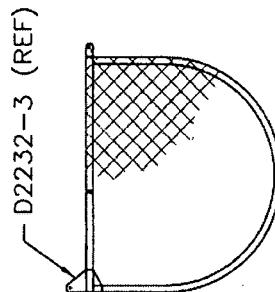
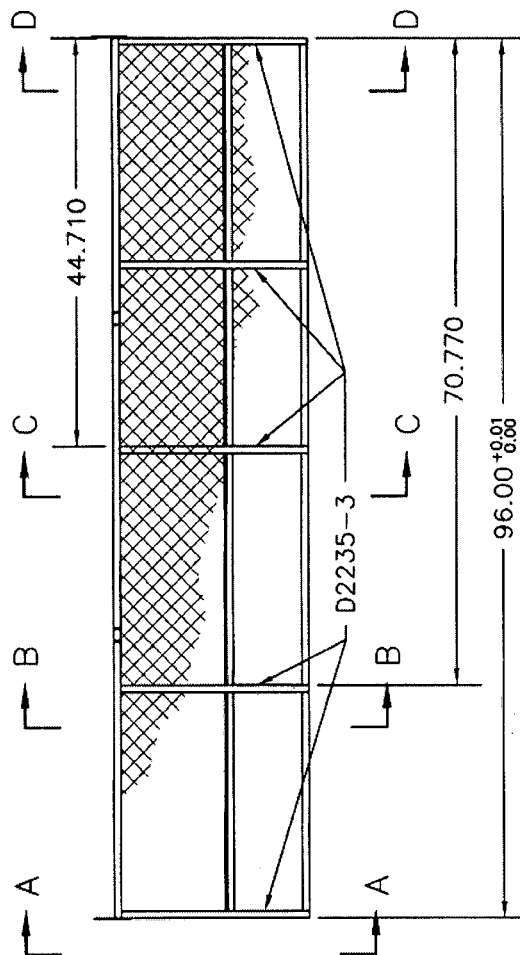
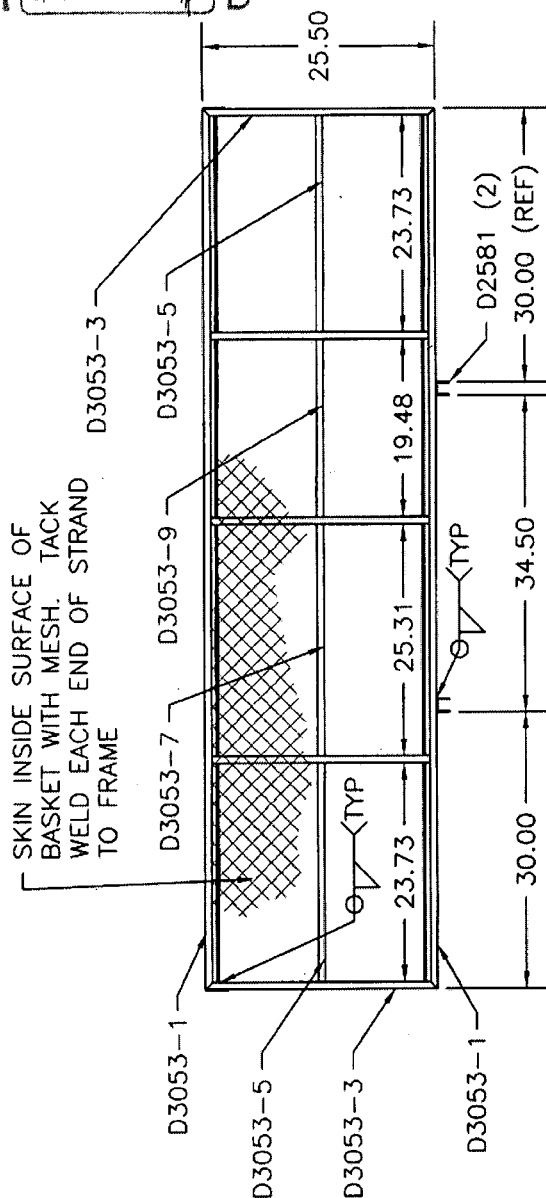
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3053	REV. A SHEET 2 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:20

RELEASED  
01.12.20



D3053-042 BASKET BASE ASSEMBLY SHOWN  
(D3053-041 BASKET BASE ASSEMBLY OPPOSITE)

**UNDER REVIEW**  
08.02.06

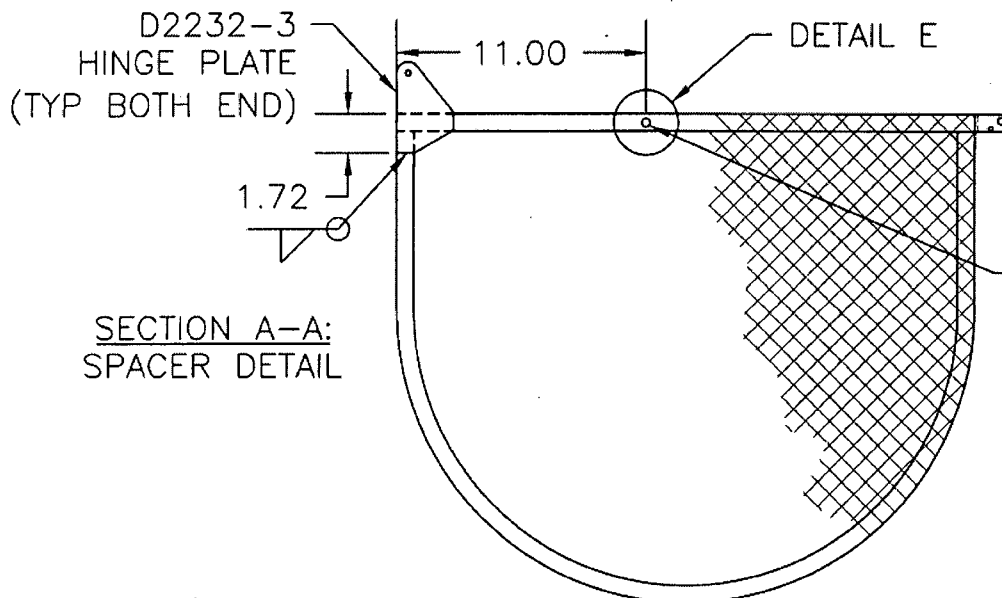
SHOP COPY  
TUBING TO BE  
CHANGED TO CROSS  
WALL  
ENGINEERING  
UNCONTROLLED COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 37413B

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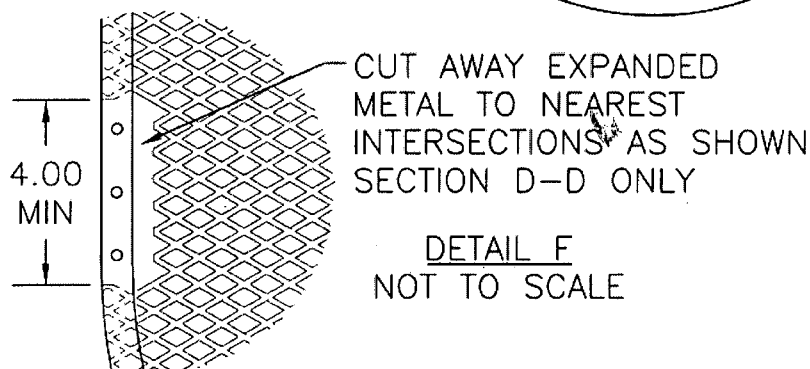


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3053	REV. A SHEET 3 OF 3
DATE 01.11.01		TITLE BASKET BASE ASSEMBLY (212)	SCALE 1:8

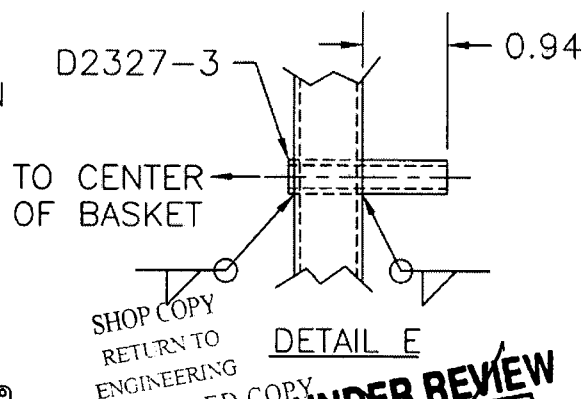


RELEASED  
01-12-20 [Signature]

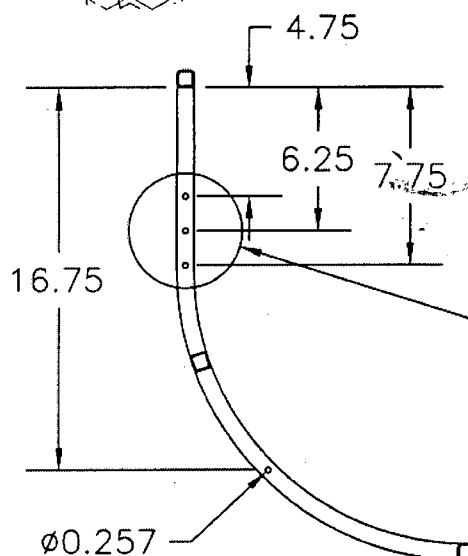
DRILL 3/8 HOLE  
AND INSTALL  
D2327-3 USING  
CLOSEST SPACE IN  
EXPANDED METAL  
FOR HOLE LOCATION  
BOTH ENDS



DETAIL F  
NOT TO SCALE



DETAIL E



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 11.5537413B

UNDER REVIEW  
08.02.05 [Signature]  
TUBING TO BE  
CHANGED TO 1.065  
WALL

SECTION B-B,  
SECTION C-C AND  
SECTION D-D:  
RIB DETAIL

DRILL 0.257 DIA HOLES  
USE DRILL JIG T2489DJ  
(SEE DETAIL F)

EXPANDED METAL

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